HSW-15 and HSW-25

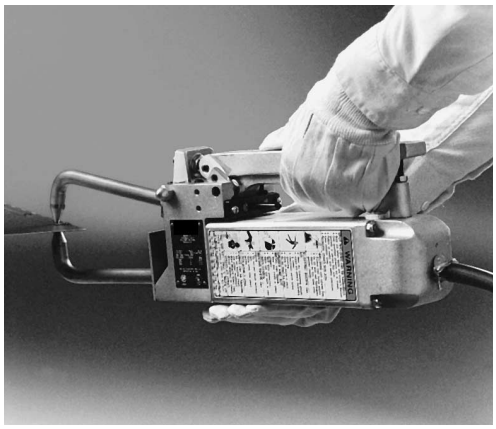
Portable Resistance Spot Welders

211804
Dec. 2002

PROCESSES

Resistance Spot Welding

5/3/1 WARRANTY



These lightweight, air-cooled units are portable, easy to operate, and provide a quick and effective means for spot welding mild, galvanized or stainless materials. These units are an excellent choice for maintenance work, and for spot welding applications that require portability and lower amperage welding.

The **HSW-15 Models** weld up to 1/8 in (3.2 mm) total material thickness or two pieces of 20 gauge (1.8 mm) galvanized metal. The **HSW-25 Models** weld up to 3/16 in (4.8 mm) total material thickness or two pieces of 16 gauge (3 mm) galvanized metal.

"T" Models include a timer panel with a 0 to 5 second weld timer and power on/off switch, and come with a 10 ft (3 m) input power cord and 10 ft (3 m) interconnecting cord. The timer panel can be mounted on the optional SWP-2 pedestal, or any other convenient location.

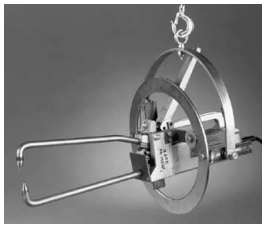
Features

- Accommodates a wide variety of tongs and tips
- Hand lever locks tongs firmly on material, ensures positive, accurate fit-up
- Quick and easy adjustment for material thickness
- Reversible for left- or right-hand operation
- Includes power cord with plug and standard 6 in (152 mm) tongs with tips

OPTIONS AND ACCESSORIES

SWP-2 Spot Welder Pedestal #040 872-01-8
Leaves hands free to handle the work. When foot control is depressed, tongs close and the start switch is activated.

Spot Weld Timer
#041 081-01-2 HSW-15
#041 082-01-1 HSW-25
Cannot be used on "T" model units. Provides 0 – 5 second mechanical weld timer.



Gyro Bail #041 979
Supports weight of welder. Operates with boom and counterweight or from spring-loaded cable. Spot welds in any position.

SPECIFICATIONS *(SUBJECT TO CHANGE WITHOUT NOTICE.)*

1 Phase

Model	Input 50/60 Hz	Amps	Work Capacity (Combined thickness uncoated mild steel using 6 in [152 mm] tongs)	Rated Output at 50% Duty Cycle	Rated Output (Calibrated with standard-type tongs) 6 in (152 mm)	12 in (305 mm)	18 in (457 mm)	Max Open-Circuit Voltage	Dimensions	Weight
HSW-15	110 VAC	30	1/8 in (3.2 mm)	1.5 kVA	5550 A	4500 A	3600 A	1.6	H: 6 in (152 mm) W: 3-1/4 in (83 mm) D: 13 in (330 mm)	Net: 22 lb (10 kg) Ship: 26 lb (12 kg)
HSW-15T										Net: 34 lb (15 kg) Ship: 38 lb (17 kg)
HSW-25	220 VAC	30	3/16 in (4.7 mm)	2.5 kVA	6750 A	5800 A	4850 A	2.5	H: 6 in (152 mm) W: 3-1/4 in (83 mm) D: 16 in (406 mm)	Net: 30 lb (14 kg) Ship: 33 lb (15kg)
HSW-25T										Net: 42 lb (19 kg) Ship: 45 lb (20 kg)

Certified by Canadian Standards Association to both Canadian and U.S. Standards.

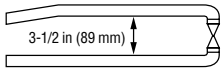
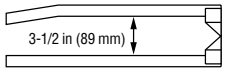
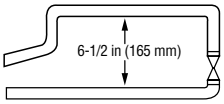
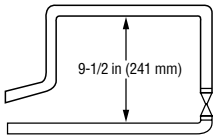
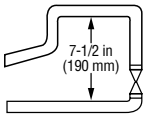
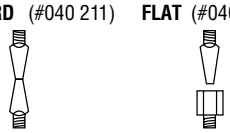
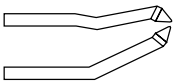
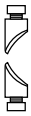
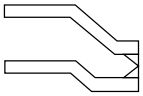
Hobart Welders An Illinois Tool Works Company

U.S. Sales	Phone 920-735-4576	FAX 800-637-2315
Canadian Sales	Phone 888-489-9353	FAX 519-421-0480
International Sales	Phone 920-735-4509	FAX 920-735-4125

Web Site www.HobartWelders.com

TONGS AND TIPS

Important Note: Tongs and tips must be ordered separately from spot welders. One standard 6 in (152 mm) tong and tip supplied with the spot welder.

TONGS		TIPS
	**STANDARD** 6 in (152 mm) (#040 197) 12 in (305 mm) (#040 198) 18 in (457 mm) (#040 199)	**STANDARD** (#040 211) **FLAT** (#040 212)
	**MO OFFSET** 6 in (152 mm) (#040 200) 12 in (305 mm) (#040 201) 18 in (457 mm) (#040 202)	**MO OFFSET** (#040 215)
	**TT-6** 12 in (305 mm) (#040 203) 18 in (457 mm) (#040 204)	**STANDARD** (#040 211) **FLAT** (#040 212)
	**TT-9** 12 in (305 mm) (#040 205) 18 in (457 mm) (#040 206)	**STANDARD** (#040 211) **FLAT** (#040 212)
	**G-7** 8 in (203 mm) (#040 207)	**STANDARD** (#040 211) **FLAT** (#040 212) 
	**FF** 8 in (203 mm) (#040 208)	**FF** (#040 213) 
	**FH** 5 in (127 mm) (#040 209)	**FH** (#040 214)

Notes:

- ***One set of tips is supplied with each set of tongs.***
- ***Maximum welding capabilities are obtained with minimum tong length.***
- ***Tips are made of RWMA Class 2 alloy.***

ORDERING INFORMATION AND SYSTEM CHECKLIST

Equipment and Options	Stock No.	Description	Qty.	Price
HSW-15 **HSW-15T**	**#500 440** **#500 441**	110 VAC, 50/60 Hz (Does include std. tongs and tips.)		
HSW-25 **HSW-25T**	**#500 442** **#500 443**	220 VAC, 50/60 Hz (Does include tongs and tips.)		
Tongs				
Tips				
Accessories				
SWP-2 Spot Welder Pedestal	**#040 872-01-8**			
Weld Timer	**#041 081-01-2** **#041 082-01-1**	For HSW-15 For HSW-25		
Gyro Bail	**#041 979**			

Date: **Total Quoted Price:**

HOBART® WELDERS

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